

Kestopur 203/15



Kestopur 203/15 is a two-component polyurethane adhesive for gluing metal, wood, insulation materials and fiber composite in sandwich panels in the transportation industry.



- Strong bond
- Durable
- Suitable for automatic application in multi-component systems

AREA OF APPLICATION

Kestopur 203/15 gives a strong, yet an elastic bond. Ideal for automatic application. Special characteristics of the adhesive is its tough grip on metal surfaces and lower viscosity than normally with Kestopur-adhesives. Suitable for e.g. gluing of metals, wood, insulation materials and fiber composite. Used in conjunction with Kestopur 200/S -hardener.

INSTRUCTIONS FOR USE

The surfaces to be bonded must be clean and dry. Remove oxides by sanding, and grease etc. dirt with Kiilto Cleaner 303. The properly cleaned surface can be sanded and then primed to improve adhesion. Remove the sanding dust carefully prior to adhesive application. Stir Kestopur 203/15 -resin before use. Add Kestopur 200/S hardener to resin and mix until a uniform colour is achieved. Apply the adhesive on one or both sides of the materials to be bonded. Fresh adhesive stains are removed with a dry cloth and then surfaces are cleaned with Kiilto Cleaner 303 or Kiilto Cleaner 302. Cured adhesive can only be removed by mechanical means. We recommend gluing at room temperature. The open time of the adhesive depends on temperature and air humidity. However, the gluing can be carried out at lower temperatures (even at +10 °C), but then the pressing time will be significantly longer and spreading properties will suffer. Higher pressing temperature will shorten the pressing time.

ADDITIONAL INFORMATION

The information given in this product data sheet is based on our tests and our practical knowledge. The technical data is defined in standard conditions. Variations in local working conditions and methods will affect the product performance and result. The result is strongly affected by working methods. We guarantee the high quality of our products according to our Quality Management System. No liability can be accepted from incorrect use of the product or prevailing conditions, over which we have no control. Thus, we cannot be held responsible for the final result. The user of the product must test the product's suitability for the intended application.

ENVIRONMENT AND SAFETY

Avoid unnecessary skin contact with and exposure to the uncured product: use safety gloves. Refer to the specific material safety data

TYPE/BINDER	Polyurethane
DENSITY/SPECIFIC WEIGHT	Resin: 1.6 g/cm ³ , Hardener: 1.2 g/cm ³
LAP SHEAR STRENGTH	SS-SS 9 N/mm ² , Al ≥ 5 N/mm ² (28 d 23 °C, 50 % RH)
TENSILE STRENGTH	7 N/mm ² (DIN 53504)
ELONGATION AT BREAK	25 % (DIN 53504)
HARDNESS	Shore D 50
MIXING RATIO	5 weight part Kestopur 203/15 -resin + 1 weight part Kestopur 200/S -hardener
VISCOSITY	Resin: approx. 13.000 mPas, Hardener: approx. 250 mPas (Brookfield RVT +20 °C)
MIXTURE VISCOSITY	approx. 5000 mPas (Brookfield RVT +20 °C)
MIXTURE COLOUR	Beige
POT LIFE	approx. 15 min. (120 g, 20°C, 50 % RH)
OPEN TIME	max. 45 min (23 °C, RH 50 %)
CONSUMPTION	150–500 g/m ² depending on materials
PRESSING TIME	min. 2 h 15min / 20 °C
STORAGE	Unopened at +10–25 °C in a container (1000 l) for 6 months, in smaller containers 12 months. After long storing, stir before use.



sheet. Go to www.kiilto.com for more information on product and package disposal.